



Dart Aerospace Ltd.
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RBE332A94-3400-03-24**Job Sheet 199371****Part No:** RBE332A94-3400-03-24**Job Qty:** 3 pcs**Part Name:** Target Block 1 User**Part Weight:** 0 lbs**Status:** New**Priority:** Medium**Job Created:** 8/21/19**Job Tracking No:****Due Date:** 11/22/19**Created By:** Marie Lajeunesse**Type:** SOLD**Description:****Note:** DWG RBE332A94-3400-03 Rev A IPP Rev. A 19.02.19 New issue DP Verify DD**Ship Via:****Bill of Materials**

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CANADA
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Container No: S211511**Part:** RBE332A94-3400-03-24**Job No:** 199371**Serial No/Batch:** S211511**Revision:** A**Inspector:****Exp Date:****Instructions:****Date:** 08/05/19

Job Routing								
Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier	Sign-off
					Setup Hrs	Run Hrs	Workcenter / Supplier Lead Time	
100	Small Fab - 1	3 pcs	11/22/19	0.00	0.60	Small Fab - 1		MCL
						Small Fab - 2		
						Small Fab - 3		
						Small Fab - 4		
						Small Fab - 5		
						Small Fab - 6		
						Small Fab - 7		
						Small Fab - 8		
110	QC 5	3 pcs	11/22/19	0.00	0.00	QC 5 - 10		D'S SEP 05 2019 40 9-89
						QC 5 - 12		
						QC 5 - 17		
						QC 5 - 18		
						QC 5 - 19		
						QC 5 - 22		
						QC 5 - 24		
						QC 5 - 3		
						QC 5 - 43		
						QC 5 - 49		
						QC 5 - 51		
						QC 5 - 58		
						QC 5 - 68		
						QC 5 - 9		
						QC 5 - 50		
						QC 5 - 30		
						QC 5 - 40		
						QC 5 - 61		
QC 5 - 81								
120	Packaging 3-1 - Stock - B4B	3 pcs	11/22/19	0.00	0.00	Packaging 3 - 1 - B4B		D'S SEP 05 2019 GA-140F
						Packaging 3 - 2 - B4B		
						Packaging 3 - 3 - B4B		
						Packaging 3 - 4 - B4B		
						Packaging 3 - 5 - B4B		
						Packaging 3 - 6 - B4B		
						Packaging 3 - 7 - B4B		
						Packaging 3 - 8 - B4B		
						Packaging 3 - 9 - B4B		
						Packaging 3 - 10 - B4B		
130	QC 21 - SA	3 pcs	11/22/19	0.00	0.00	QC 21 - SA - 21		D'S SEP 05 2019
						QC 21 - SA - 70		
						QC 21 - SA - 53		

Part Op 100 - 1-Do NOT remove clear protective film prior to assembly. 2-Assemble as per DWG. See note 8 and 9.
 Descriptions: 110 - QC5- Inspect part completeness to step on W/O
 120 - The tool must be packaged with a desiccant bag into a tight fitting sealed plastic bag as per DWG.
 130 - QC21- Final Inspection - Work Order Release

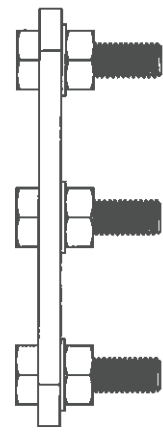
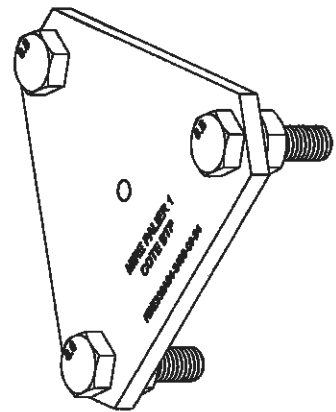
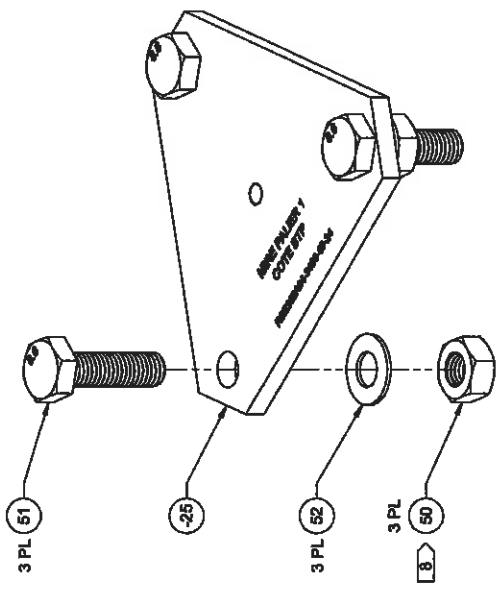
Job BOM				
Part / Item	Component Name	Quantity	Operation	Container
90591A171	Hex Nut	9 Ea (3 ea)	100-Small Fab - 1	FM138414-8
91280A636	Hex Head Cap Screw	9 Ea (3 ea)	100-Small Fab - 1	5x 5157274 4x 5047600
98023A031	Yellow Zinc Plated Grade 8 Steel Washer 0.406" ID. X 0.812" OD. X 0.051"-0.080" THK.	9 Ea (3 ea)	100-Small Fab - 1	5157242
RBE332A94-3400-03-25	Base	3 pcs (1 ea)	100-Small Fab - 1	5165299
Job Allocations				
Operation	Component Part	Required	Inventory	Allocated
100-Small Fab - 1	90591A171	9	64	0
	91280A636	9	49	0
	98023A031	9	64	0
	RBE332A94-3400-03-25	3	3	0
Part Specifications				
Specifications could not be found.				

Plex 8/21/19 8:02 AM Dart.lajeunesse.marie

8 7 6 5 4 3 2 1

ITEM #	QTY	PART #	PART TITLE
-25	1	RBE332A94-3400-03-25	BASE
50	3	McMaster#90581A171 OR EQUIV.	ZINC PLATED CLASS 8 STEEL HEX NUT M10 X 1.5 mm X 8 mm HT.
51	3	McMaster#91280A636 OR EQUIV.	ZINC PLATED CLASS 8.8 STEEL HEX HEAD SCREW M10 X 1.5 mm X 35 mm LG.
52	3	McMaster#98023A031 OR EQUIV.	YELLOW ZINC PLATED GRADE 8 STEEL WASHER 0.408" ID. X 0.812" OD. X 0.051"-0.080" THK.

D C B A



SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 199371 MJS
19-08-21

RBE332A94-3400-03-24 TARGET BLOCK 1 USER

- NOTES:
- 1) MATERIAL: N/A
 - 2) HEAT TREAT: N/A
 - 3) FINISH: N/A
 - 4) TOLERANCES: X.X = $\pm 0.1"$ / $\pm 1"$
X.XX = $\pm 0.01"$ / $\pm 0.5"$
X.XXX = $\pm 0.005"$ / $\pm 0.1"$
X.XXXX = $\pm 0.0005"$ / $\pm 0.05"$
PARALLELISM, ECCENTRICITY AND SYMMETRY ABOUT ALL CENTER LINES = $\pm 0.005"$
 - 5) UNITS: INCHES UNLESS OTHERWISE NOTED
 - 6) IDENTIFICATION: N/A
 - 7) ASSEMBLY AS SHOWN
 - 8) INSTALL ITEM 50 HAND TIGHT
 - 9) THE TOOL ASSY MUST BE PACKAGED WITH A DESICCANT BAG INTO A TIGHT FITTING SEALED PLASTIC BAG

DESIGN	KPT	DART AEROSPACE LTD
DRAWN	KPT	HAWKESBURY, ONTARIO, CANADA
CHECKED	MBB	REV. A
MFG. APPR.	DP	TOOL PART #
APPROVED	VP	RBE332A94-3400-03
DATE 2/14/2019		TITLE
		T/R DRIVE ALIGNMENT INSPECTION
		SCALE
		SHEET 25 OF 26
		NTS
		THIS DOCUMENT IS A PART OF A CONTRACT AND IS NOT TO BE REPRODUCED OR TRANSMITTED IN ANY FORM OR BY ANY MEANS, ELECTRONIC OR MECHANICAL, WITHOUT PERMISSION IN WRITING FROM DART AEROSPACE LTD.



Entered: _____ Date: _____

WORK ORDER NON-CONFORMANCE / ROUTE UPDATE

Route update only

NCR No. _____

Job: _____ Part No. _____		DISPOSITION		DEPARTMENT/PROCESS																																																																											
Date: _____		Sequence #: _____		QTY Affected: _____																																																																											
Description Work Order Deviation		Disposition		MRB (QS1042)																																																																											
Root Cause <table border="1"><tr><td>Operator</td><td></td></tr><tr><td>Manufacturing Process</td><td></td></tr><tr><td>Equip/Tooling</td><td></td></tr><tr><td>Handling/Preservation</td><td></td></tr><tr><td>Material</td><td></td></tr><tr><td>Product Improvement</td><td></td></tr><tr><td>Process Improvement</td><td></td></tr><tr><td>Human Factors</td><td></td></tr></table>		Operator		Manufacturing Process		Equip/Tooling		Handling/Preservation		Material		Product Improvement		Process Improvement		Human Factors		<table border="1"><tr><td>Pressure/Forced</td><td></td></tr><tr><td>Bending</td><td></td></tr><tr><td>Crushing</td><td></td></tr><tr><td>Cracks</td><td></td></tr><tr><td>Crimp/Kink/Ripple/Wave/Twist</td><td></td></tr><tr><td>Marks/Chatter</td><td></td></tr><tr><td>Mislabeled</td><td></td></tr><tr><td colspan="2">Other/Details:</td></tr></table>		Pressure/Forced		Bending		Crushing		Cracks		Crimp/Kink/Ripple/Wave/Twist		Marks/Chatter		Mislabeled		Other/Details:		FAULT CATEGORY <table border="1"><tr><td>Contamination</td><td></td></tr><tr><td>Misaligned/off center</td><td></td></tr><tr><td>BOM/Route</td><td></td></tr><tr><td>Broken/Damage/Defect</td><td></td></tr><tr><td>Incomplete/Unclear Instructions</td><td></td></tr><tr><td>Drill Holes</td><td></td></tr><tr><td>Fit/Function</td><td></td></tr><tr><td>Power Loss/Surge</td><td></td></tr><tr><td>Folio/Program</td><td></td></tr><tr><td>Grain Direction</td><td></td></tr><tr><td>Weld</td><td></td></tr><tr><td>Wrong Stock Pulled</td><td></td></tr><tr><td>Out of Sequence</td><td></td></tr><tr><td>Off-set/Set-up</td><td></td></tr></table>		Contamination		Misaligned/off center		BOM/Route		Broken/Damage/Defect		Incomplete/Unclear Instructions		Drill Holes		Fit/Function		Power Loss/Surge		Folio/Program		Grain Direction		Weld		Wrong Stock Pulled		Out of Sequence		Off-set/Set-up		<table border="1"><tr><td>Positioned Wrong</td><td></td></tr><tr><td>Outside Tolerance</td><td></td></tr><tr><td>Drawing</td><td></td></tr><tr><td>Finish</td><td></td></tr><tr><td>Part Lost/Missing</td><td></td></tr><tr><td>Misread</td><td></td></tr></table>		Positioned Wrong		Outside Tolerance		Drawing		Finish		Part Lost/Missing		Misread	
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